

Work Order ID 61225

August 11, 2010 11:05:15 AM



Page 1

Item ID:	D2932-1UP	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 Saddle Left side-unpainted					
Start Date:	8/11/10	Start Qty:	6.00	Cust Item ID:		
Required Date:	8/25/10	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>10/8/11</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2932	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo Program part number and batch number. <input type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00							
	Mill Conv	0.00							
Conventional Milling Machine	Memo Machine Keyway and inspect per attached dimension sheet								
120	QC1 - Inspect dimensions to dimension sheet	0.00							
	QC	0.00							
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61225

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Item ID: D2932-1UP

Accept

Setup Start

Revision ID:

Stop

Item Name: 206 Saddle Left side-unpainted

Start Date: 8/11/10 Start Qty: 6.00

Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	BT 10/08/23			6	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				C BT 10-8-24.			
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				ml	10	08	24 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61225

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Item ID: D2932-1UP

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 Saddle Left side-unpainted

Start Date: 8/11/10 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



Packaging

Packaging

Identify as per dwg & Stock Location: _____

57434

Memo

0.00

0.00

CL 10/8/25 (C)

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/08/25 J

CL 10/8/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 11, 2010 11:05:14 AM

Page 1

Work Order ID: 61225



Parent Item: D2932-1UP



Parent Item Name: 206 Saddle Left side-unpainted


Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-04 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	22.0000	1	6			
Saddle Billet, 7075													

Location

Loc Qty

Loc Code

MAT042

22

✓59196

22

60-IST 10/08/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	6/225
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.110	0.105	0.110	0.113	118-120	Deep Mic
B	0.100	0.140		0.110	0.105	0.110	0.113		"
C	0.100	0.140		0.115	0.117	0.120	0.120		"
D	0.210	0.230		0.215	0.220	0.220	0.220	DTP-02	Mic
E	1.245	1.255		1.250	1.250	1.250	1.250	DTP-11	Vern
F	1.245	1.255		1.250	1.250	1.250	1.250		"
G	2.495	2.505		2.500	2.500	2.500	2.500		"
H	0.510	0.515		0.511	0.511	0.511	0.511		"
I	1.572	1.582		1.577	1.577	1.577	1.577		"
J	2.495	2.505		2.500	2.500	2.500	2.500		"
K	0.257	0.262		0.259	0.259	0.259	0.259		"
L	0.312	0.317		0.316	0.316	0.316	0.316		"
M	0.235	0.240		0.238	0.238	0.238	0.238	DTP-02	Mic
N	0.100	0.140		0.115	0.121	0.120	0.1215		"
O	0.540	0.560		0.540	0.546	0.546	0.545	DTP-11	Vern
P	0.490	0.510		0.501	0.498	0.500	0.499		"
Q	3.715	3.725		3.720	3.720	3.720	3.720		"
R	2.470	2.510		2.487	2.490	2.490	2.490		"
S	0.240	0.270		0.250	0.245	0.251	0.250		"
T	0.100	0.180		0.140	0.140	0.140	0.140		"
U	1.625	1.635		1.630	1.630	1.630	1.630		"
V	1.362	1.372		1.367	1.367	1.367	1.367		"
W	0.316	0.321		0.318	0.318	0.318	0.318		"
X	1.125	1.145		1.1315	1.1385	1.132	1.1325		Dial
Y	1.565	1.585		1.5705	1.575	1.572	1.570		"
Z	0.178	0.198		0.188	0.188	0.188	0.188		Rad gage
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>DTP</u>
Date: <u>10/08/21</u>

Audited by: <u>SP</u>
Date: <u>10/08/23</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	61225
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

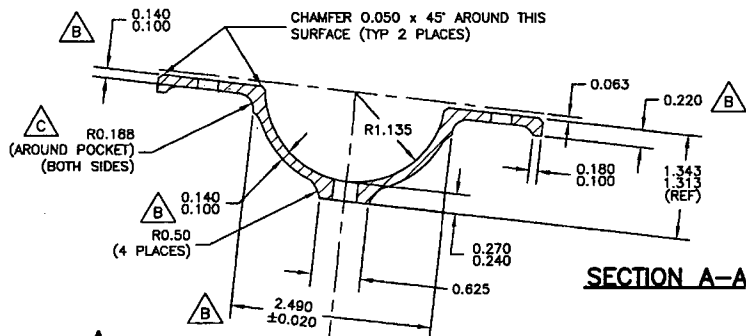
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	3	4	By	Date
A	0.100	0.140		0.112	0.115				
B	0.100	0.140		0.114	0.115				
C	0.100	0.140		0.120	0.123				
D	0.210	0.230		0.220	0.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.511	0.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.259	0.259				
L	0.312	0.317		0.316	0.316				
M	0.235	0.240		0.238	0.238				
N	0.100	0.140		0.1215	0.1205				
O	0.540	0.560		0.546	0.545				
P	0.490	0.510		0.500	0.501				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		0.250	0.251				
T	0.100	0.180		0.188	0.188				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.318	0.318				
X	1.125	1.145		1.134	1.1335				
Y	1.565	1.585		1.570	1.568				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

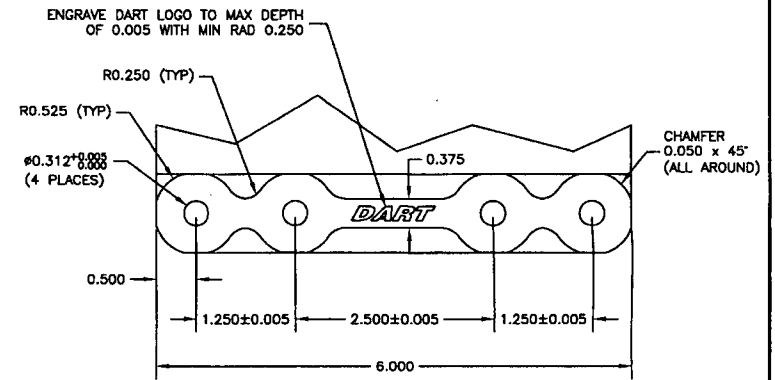
Measured by:	DTJ
Date:	10/08/21

Audited by:	[Signature]
Date:	10/08/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]



SECTION A-A



VIEW C-C

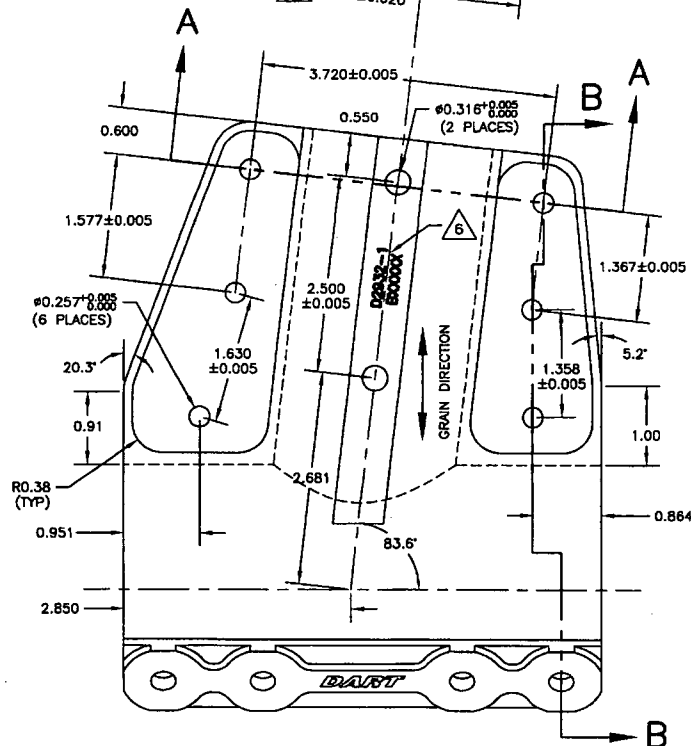
D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

CZ10/8111

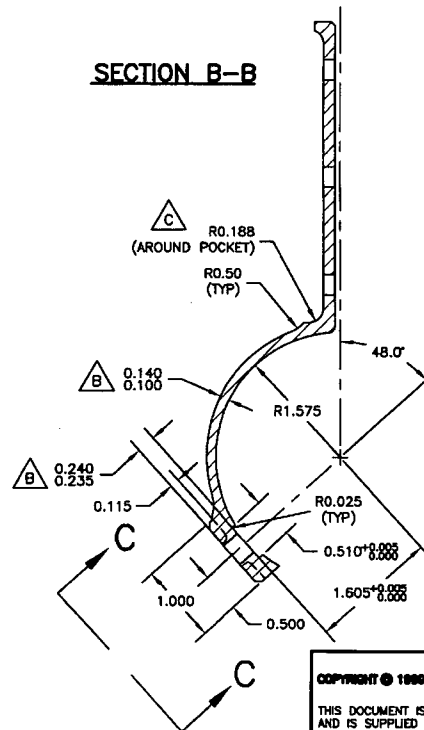
W10,61225

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



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DART AEROSPACE USA, INC.

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	D2932
DATE	TITLE	SADDLE OUTSIDE
06.11.09		

REV. C

SHEET 1 OF 1

SCALE

2:3

RELEASED

07-02-02